



ASA

Date: Monday, 22/01/2007 1:52:36 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 L/L 1/L3 SCUFF PLATE, FWD LH
Job Number : 30364	
Estimate Number : 12268	
P.O. Number : N/A	Part Number : D206555005
This Issue : 22/01/2007 S.O. No. : N/A	Drawing Number : D206-555 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C
Previous Run : 30364	Material : N/A
Written By : 	Due Date : 29/01/2007 Qty: 12 Um: Each
Checked & Approved By : 	
Comment : Est C 99.06.29 Returned to Electro Polish DM Est Rev:D Now On Waterjet 07-01-22 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
Type Labels as per PPP D206-555-005

2.0	M304S25GA	304/316 .020" Sheet
-----	-----------	---------------------



Comment: Qty.: 0.4610 sf(s)/Unit Total : 5.5320 sf(s)
304/316 .020" Sheet
Batch: M102393 ml 07 01 23 (12)

3.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D206-555
Dwg Rev: C ml 07 01 23 (12)
Prog Rev: C
2-Deburr if necessary ml 07-01-23 (12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Date: Monday, 22/01/2007 1:52:36 PM

Date: Monday, 22/01/2007 1:52:36 PM

User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, FWD LH

Job Number: 30364

Part Number: D206555005

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555 using DT 8318-5

Finish form on bench forming Jig DT 8319-5

SB 07/01/24 10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/24 (10)

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: 2930

Possible supplier: TQF Technologies

07/01/24 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

07/01/24 (10) 07/01/24 (10)

10.0

QC6

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/01/30

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

SB 07/01/30 10

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/30

DART

DESIGN JB	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

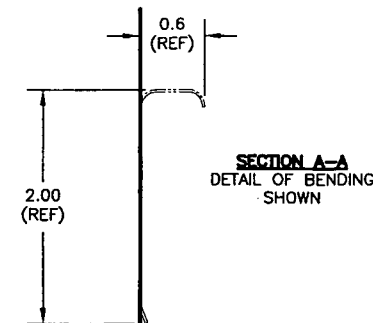
QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

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FLAT PATTERN



2.7
(REF)

8.000

Ø0.187
(2 PLACES)

14.1
(REF)

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06.09.19

D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)

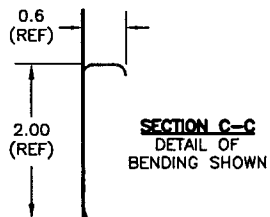
D206-555-002 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T1
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 2 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	

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DETAIL B
SCALE 1:1

REFER TO DETAIL B
FOR 1:1 SCALE

16.000 (REF)

2.7
(REF)

FLAT PATTERN

8.000

19.0
(REF)

8.000

Ø0.187
(3 PLACES)

RELEASED

06.09.19-#

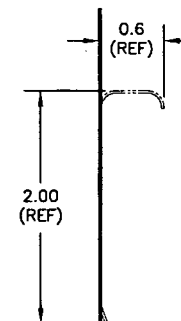
D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)

D206-555-004 (BEND OPPOSITE)

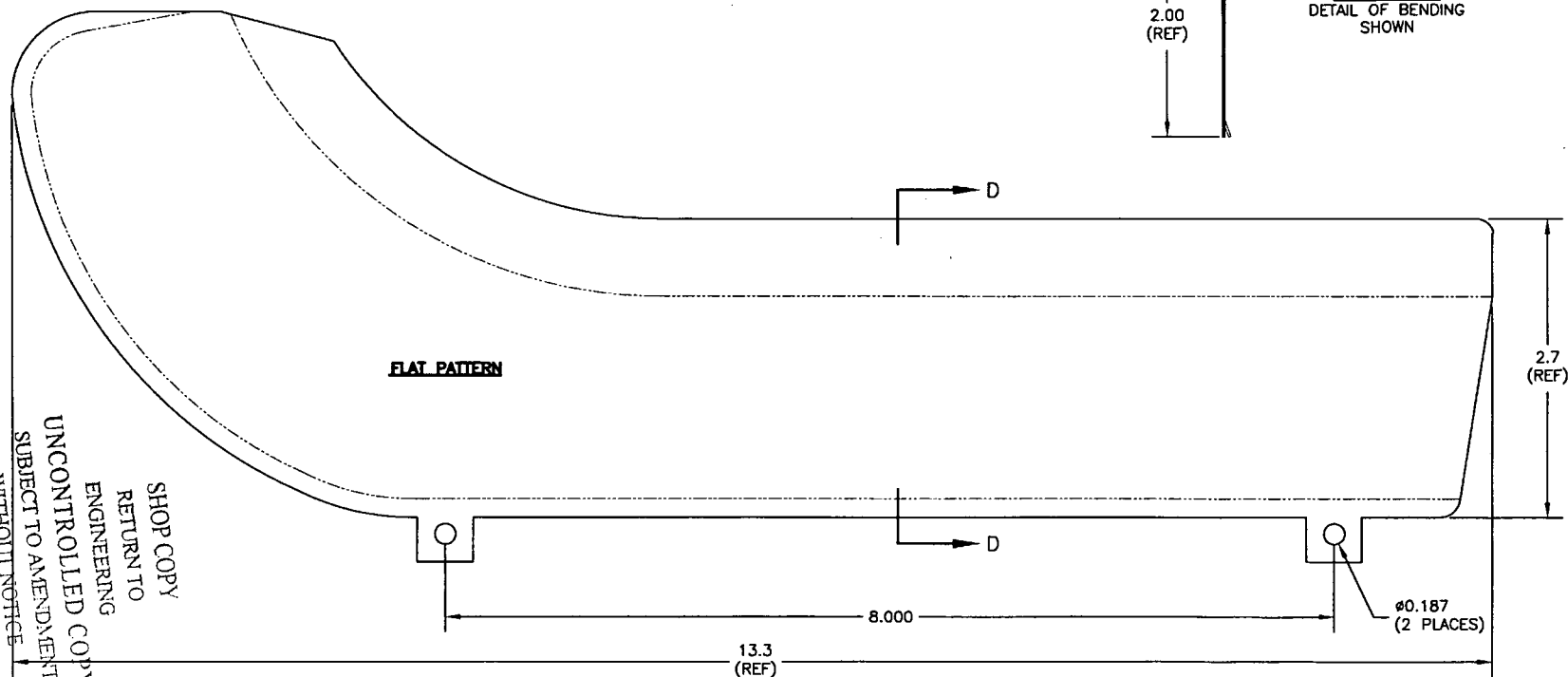
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 3 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



SECTION D-D
DETAIL OF BENDING
SHOWN



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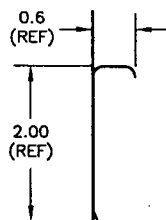
06.09.01

D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)
D206-555-006 (BEND OPPOSITE)

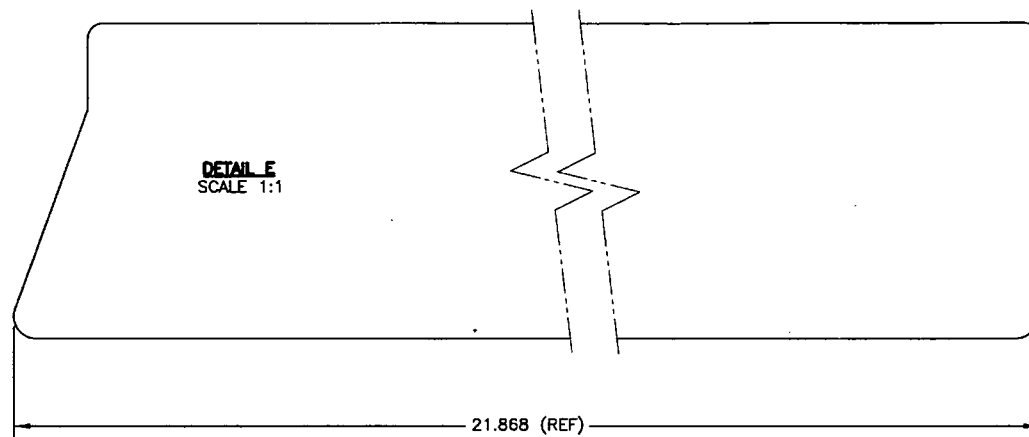
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T5
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD WARRICKBURT, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 4 OF 7 SCALE 1:1



SECTION F-F
DETAIL OF
BENDING SHOWN



REFER TO DETAIL E
FOR 1:1 SCALE

FLAT PATTERN

2.7
(REF)

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D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)

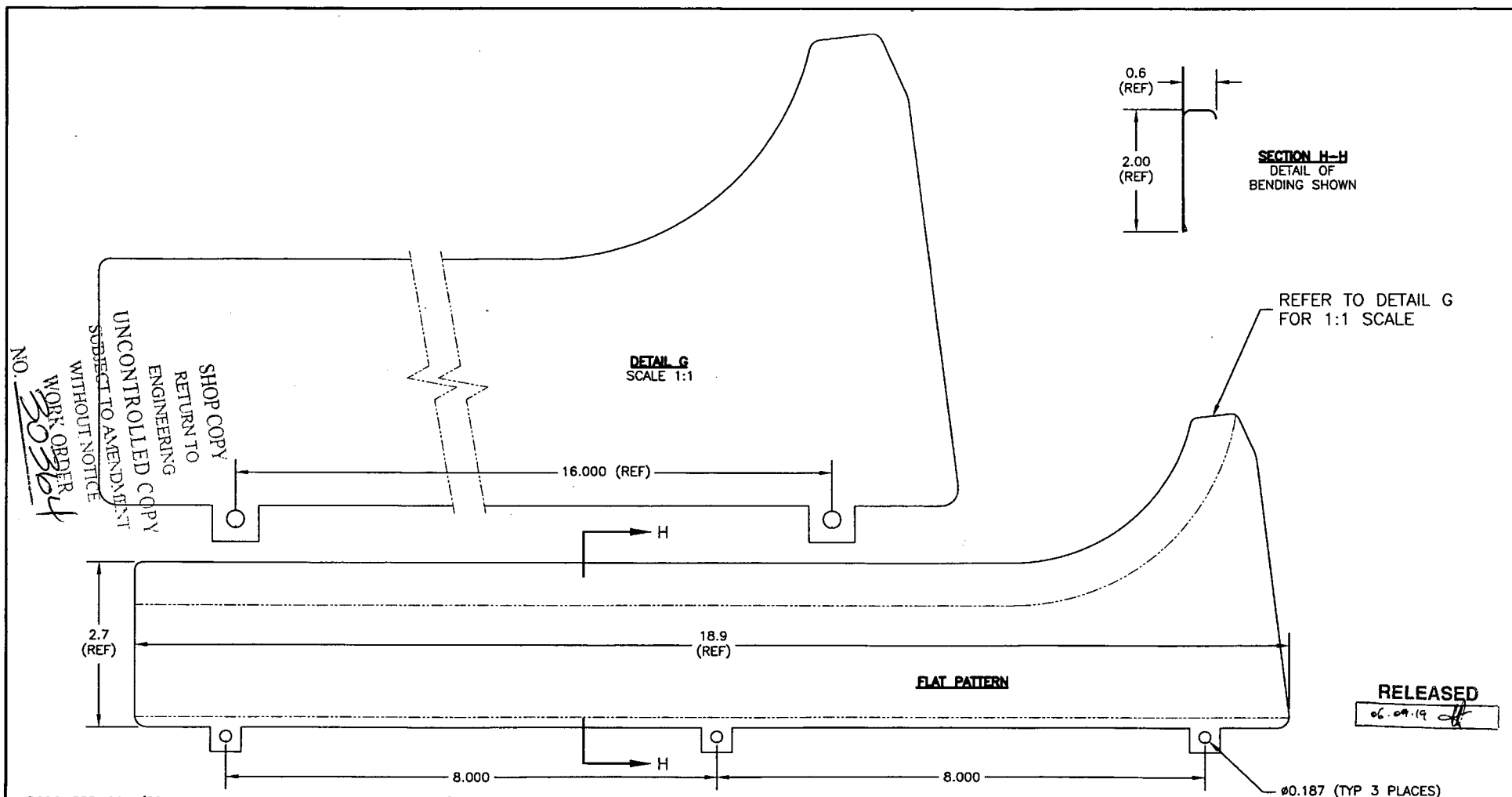
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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06.09.19 #

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CHECKED PH	APPROVED H	DRAWING NO. D206-555	SHEET 5 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	

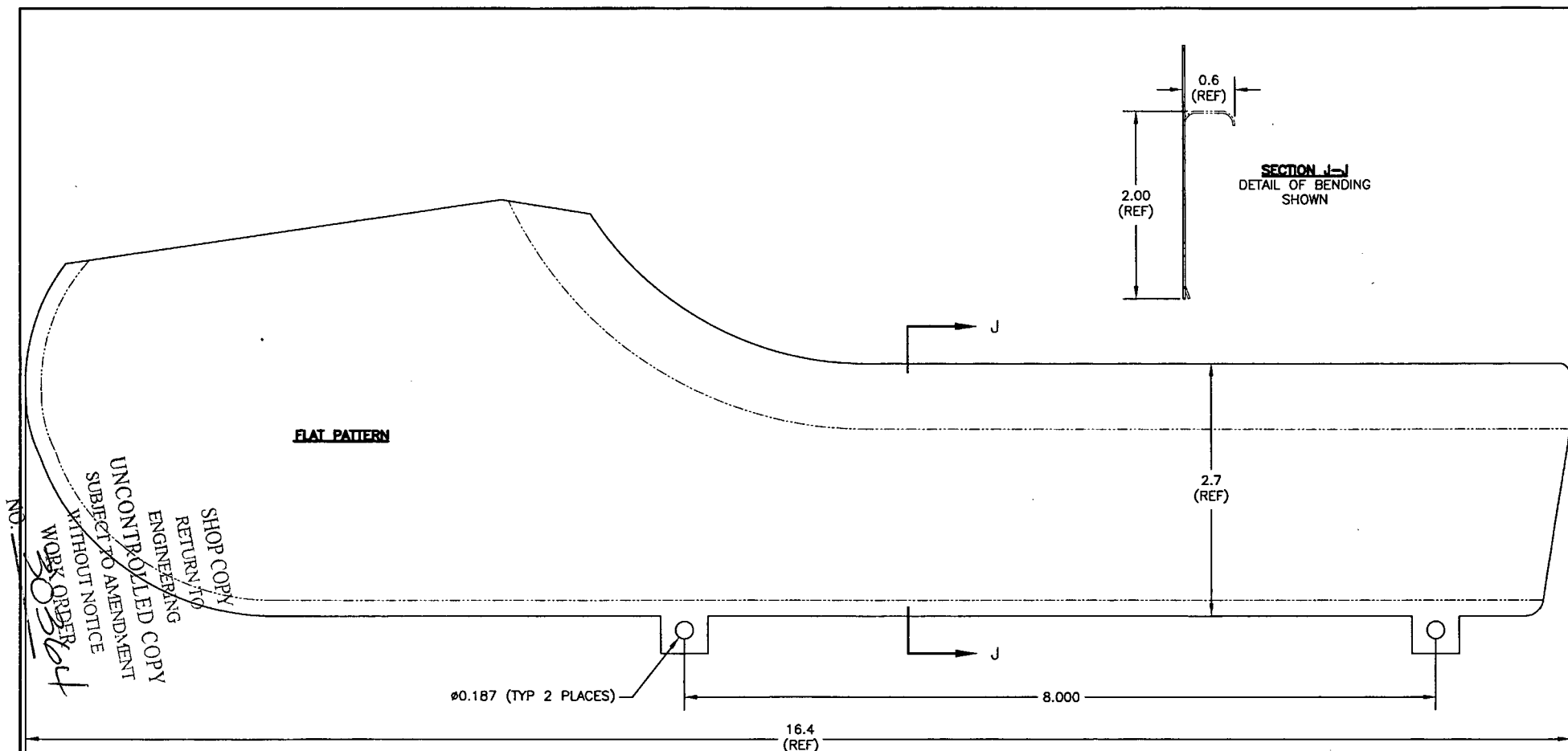


D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA	REV. C
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DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	



D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)
D206-555-012 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T11
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 7 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	



Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: January 26, 2007

1270 Aberdeen St

Hawkesbury, Ontario

No. de certificat
Certification No.

K6A 1K7

tel.: (613) 632-9577

fax: (613) 632-1053

C112101

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
123010		NO. DE COM./P.O.# 2930	ELECTROPOLISH PER ASTM B912 REV.02
	10	D206-555-005 B30364	
	12	D206-555-006 B30365	

Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et specifications et sont en accord avec les exigences ci-inclus.

We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.

Signé pour et au nom de TQF Technologies Inc.
Signed for and on behalf of TQF Technologies Inc.



Raj Thakoordeen

Total Quality Finishing